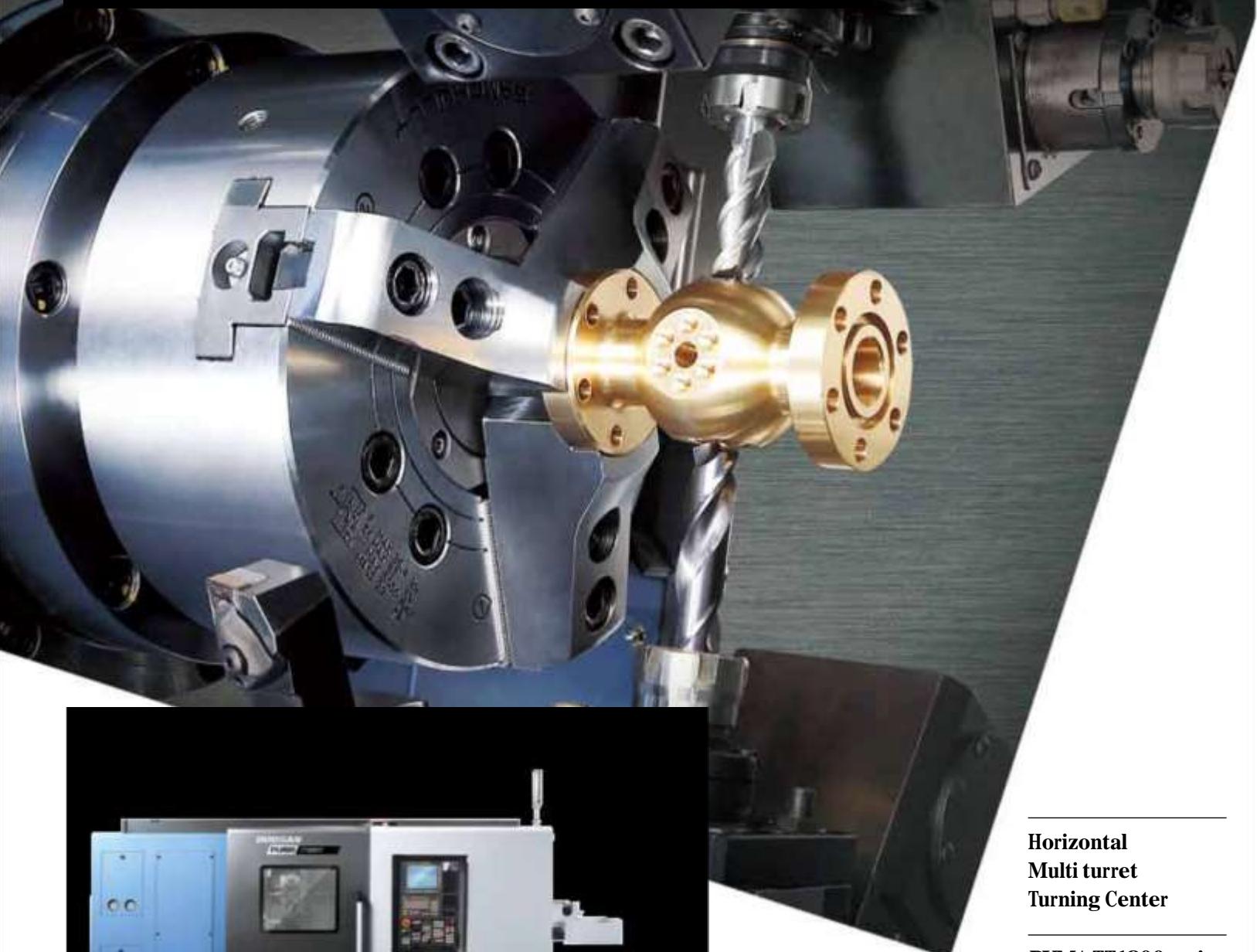


PUMA TT1800 series



**Horizontal
Multi turret
Turning Center**

PUMA TT1800 series

PUMA TT1800S
PUMA TT1800MS
PUMA TT1800SY

Basic Information

Basic Structure
Line-up /
Processing

Detailed
Information

Options
Applications
Capacity Diagram
Specifications

Customer Support
Service



PUMA TT1800 series

The Puma 1800 Series is a 65mm (2.6 inch) bar capacity high productivity horizontal turning center equipped with twin opposed spindles and upper / lower turrets. The left and right spindles can process work pieces independently to achieve excellent productivity. The work pieces processed by the left and right spindles are discharged via an automatic system. The PUMA TT Series has become one of DOOSAN's bestselling products and is favored by customers all around the world.

Contents

02 Product Overview

Basic Information

04 Basic Structure

08 Line-up / Processing

Detailed Information

11 Standard / Optional Specifications

14 Applications

17 Capacity Diagram

22 Machine / NC Unit Specifications

26 Customer Support Service

Sample



Productivity doubled with the adoption of a right spindle and a lower turret!

The left and right spindles and the upper and lower turrets operate independently to double the machine's productivity.

Excellent rigidity and power implemented with axis travel system optimization technology!

The product's rapid traverse rate of 40 m/min and High rigidity roller LM guide ways are designed to meet the required characteristics of machines whose users require a very high level of productivity.

Equipped with an advanced finished-part removal system for both spindles!

The left and right spindles are equipped with independent part catcher and unloader systems to provide a fully automated manufacturing system.



Basic Information

Basic Structure

Line-up /

Processing

Detailed

Information

Options

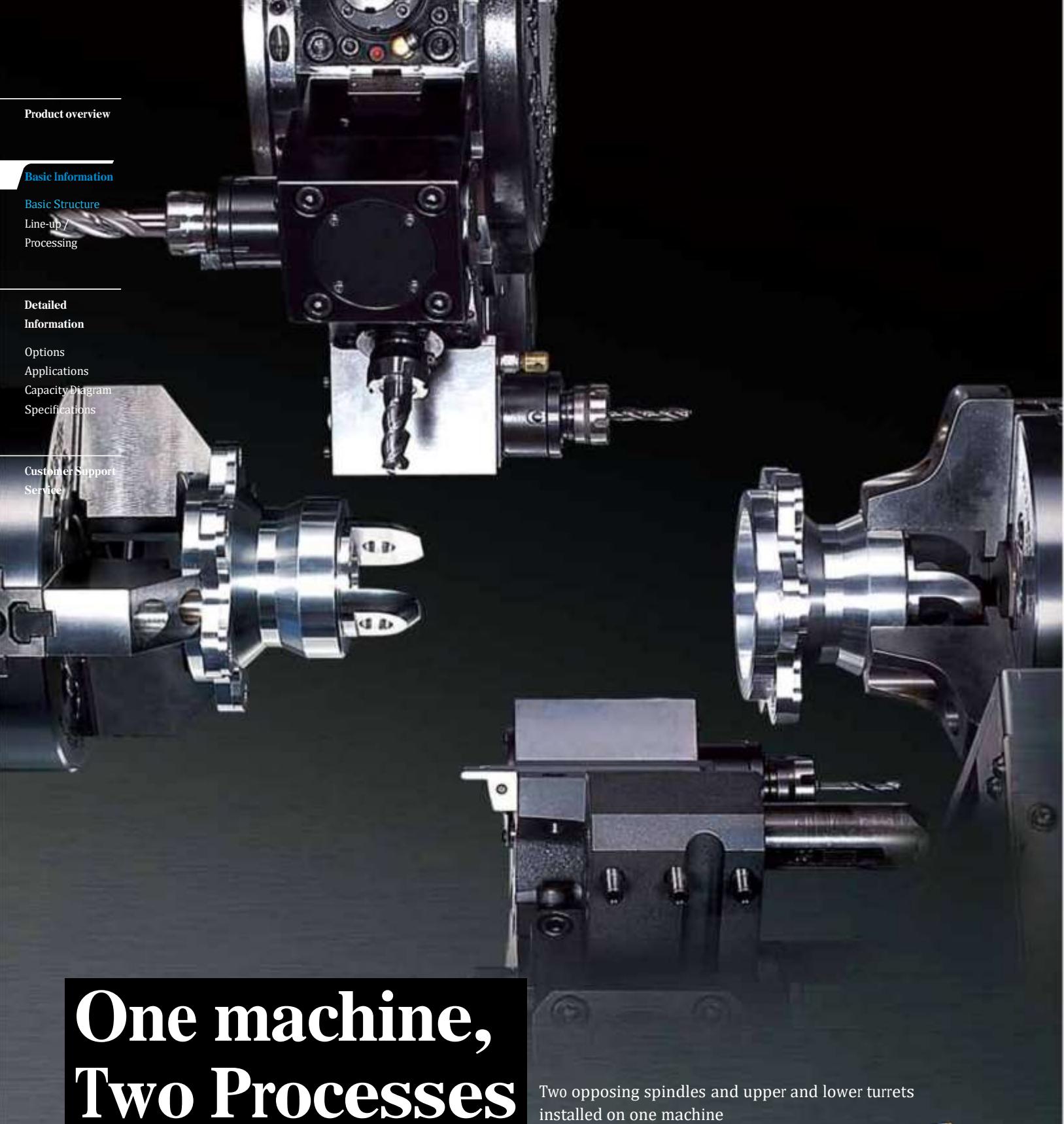
Applications

Capacity Diagram

Specifications

Customer Support

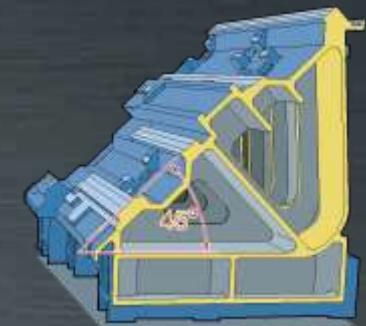
Service



One machine, Two Processes

With the adoption of two opposing spindles and upper / lower turrets, the Puma TT Series can cut both first and second operations simultaneously. Furthermore, the axis travel system, which is designed with high rigidity roller guide ways and fast federate of 40m/min, provides a high level of thermal stability.

Two opposing spindles and upper and lower turrets installed on one machine



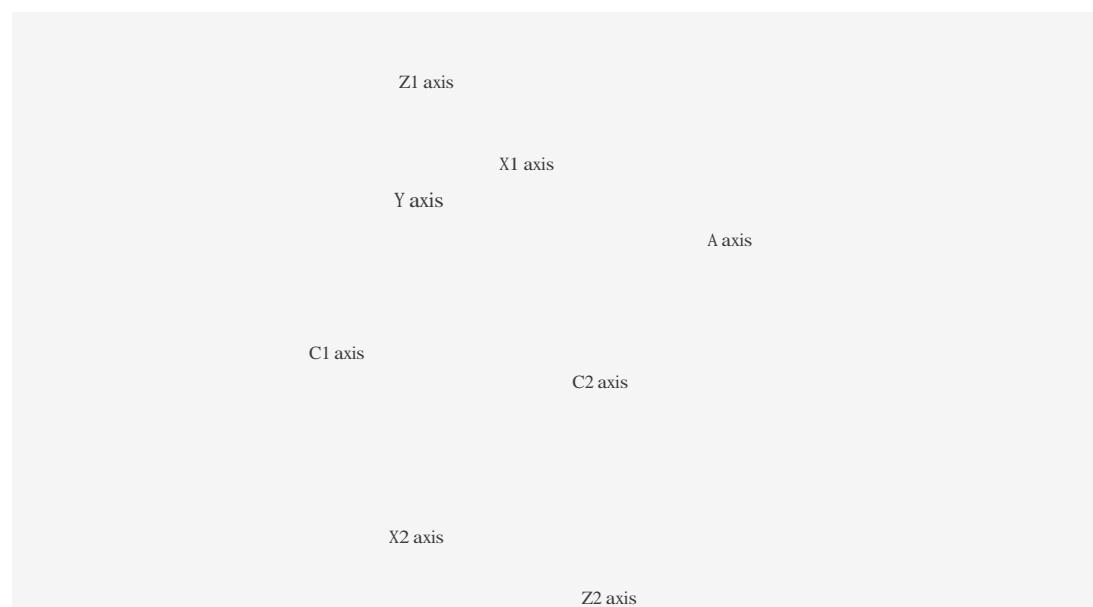
Designed as a wide-rib torque-tube structure to prevent twisting and deformation.

Basic Structure

The Z, A axes are equipped with roller LM guide ways for increased rigidity and high speed, while the X and Y axes are equipped with box guide way for optimum rigidity, thereby providing maximum productivity.

Feed Axes Constitution

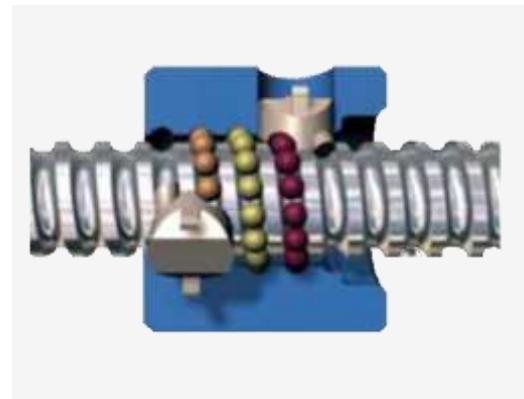
High productivity is achieved with a process-intensive structure comprising opposing types of spindles and upper and lower turrets.



Description	Unit	PUMA TT1800S / MS	PUMA TT1800SY
Travel distance	X1, X2 axes	mm (inch)	X1: 165 (6.5) / X2: 190 (7.5)
	Z1, Z2 axes	mm (inch)	Z1: 700 (27.6) / Z2: 720 (28.3)
	Yaxis	mm (inch)	-
	A axis	mm (inch)	770 (30.3)
Rapid traverse rate	X1, X2 axes	m/min (ipm)	20 (787.4)
	Z1, Z2 axes	m/min (ipm)	40 (1574.8)
	Yaxis	m/min (ipm)	-
	A axis	m/min (ipm)	40 (1574.8)

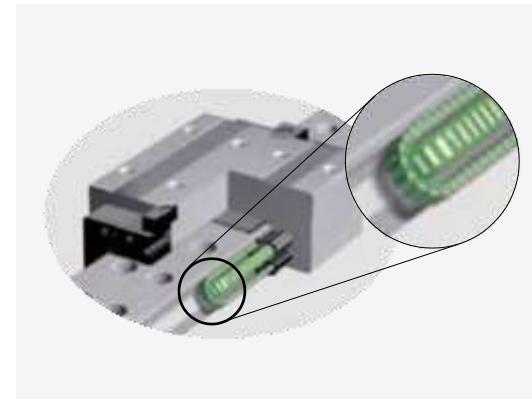
Ball Screw

The effects of changes of temperature on the travel system have been minimized with the optimized low friction ballscrew design.



LM Guide

high rigidity / high speed structure with roller LM guides on the Z and A axes.





Spindle

High productivity achieved with high-speed, high-power spindle motor.

Built-in Structure

The PUMATT series is equipped with built-in spindles to deliver high speed and responsiveness. Two opposing spindles provide the same turning performance characteristics using the same motors.

Left spindle, Right spindle (8 inch)

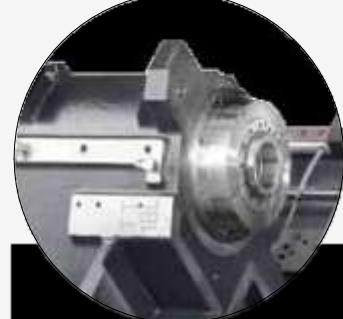
Max. Power

22 / 15 kW
(29.5 / 20.1 Hp)

Max. Speed

5,000 r/min

Left spindle



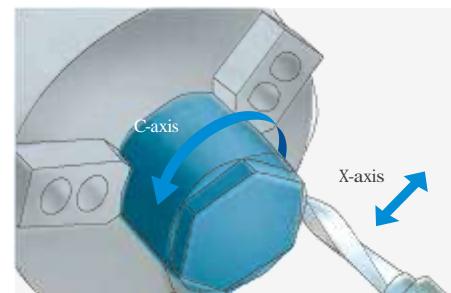
Right spindle



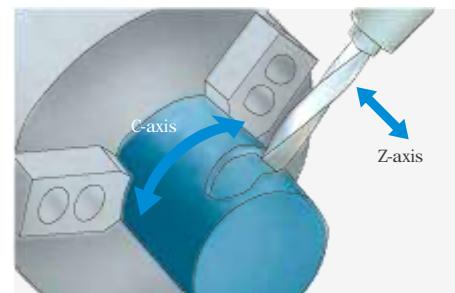
Axis Accuracy

The positioning accuracy of the C axis has been enhanced by careful assembly of C-axis sensor and applying improved servo tuning.

Polar coordinate interpolation



Cylindrical interpolation



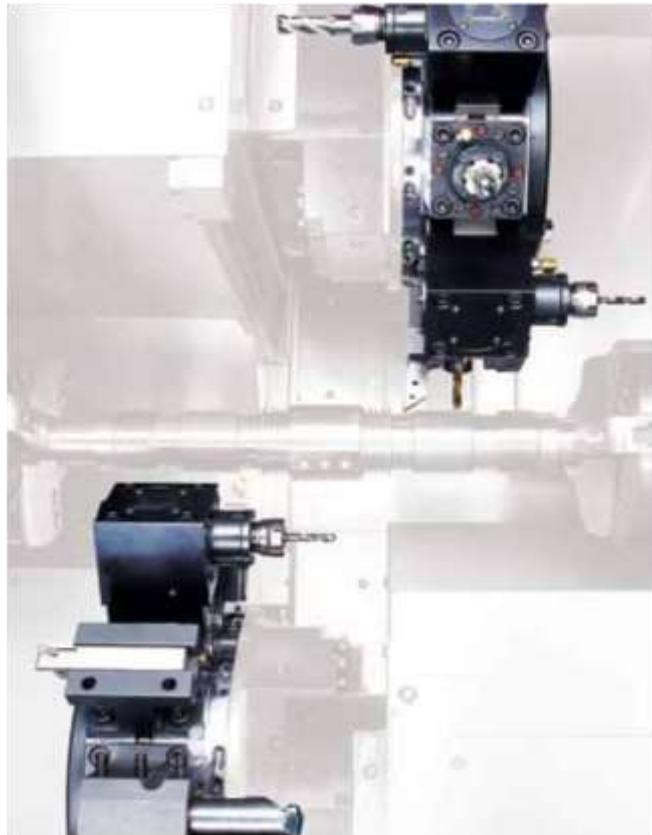


Turret

Turret with increased speed and rigidity

The upper and lower turrets double machine productivity by allowing independent, simultaneous operation.

Features stronger and faster turrets; upgraded servo motors for faster and more accurate tool rotation; and a stabilized structure for higher productivity and heavier-cutting capability.



Turret indexing time (1 face)

0.15s

No. of tool station

(the same for the upper and lower turrets)

12 station

No. of index positions

(the same for the upper and lower turrets)

24 index position

Turret with Upgraded Speed and Rigidity

The new turret has passed stricter speed and side loading tests. In addition, the cross-roller bearing reduces backlash and improves accuracy due to improved rigidity. Indexing time has been reduced by 20-30% compared with previous models.

Reduced non-cutting time

10%

Higher indexing spe

Improved accuracy



Rotary Tool Structure Highly Resistant to Thermal Error

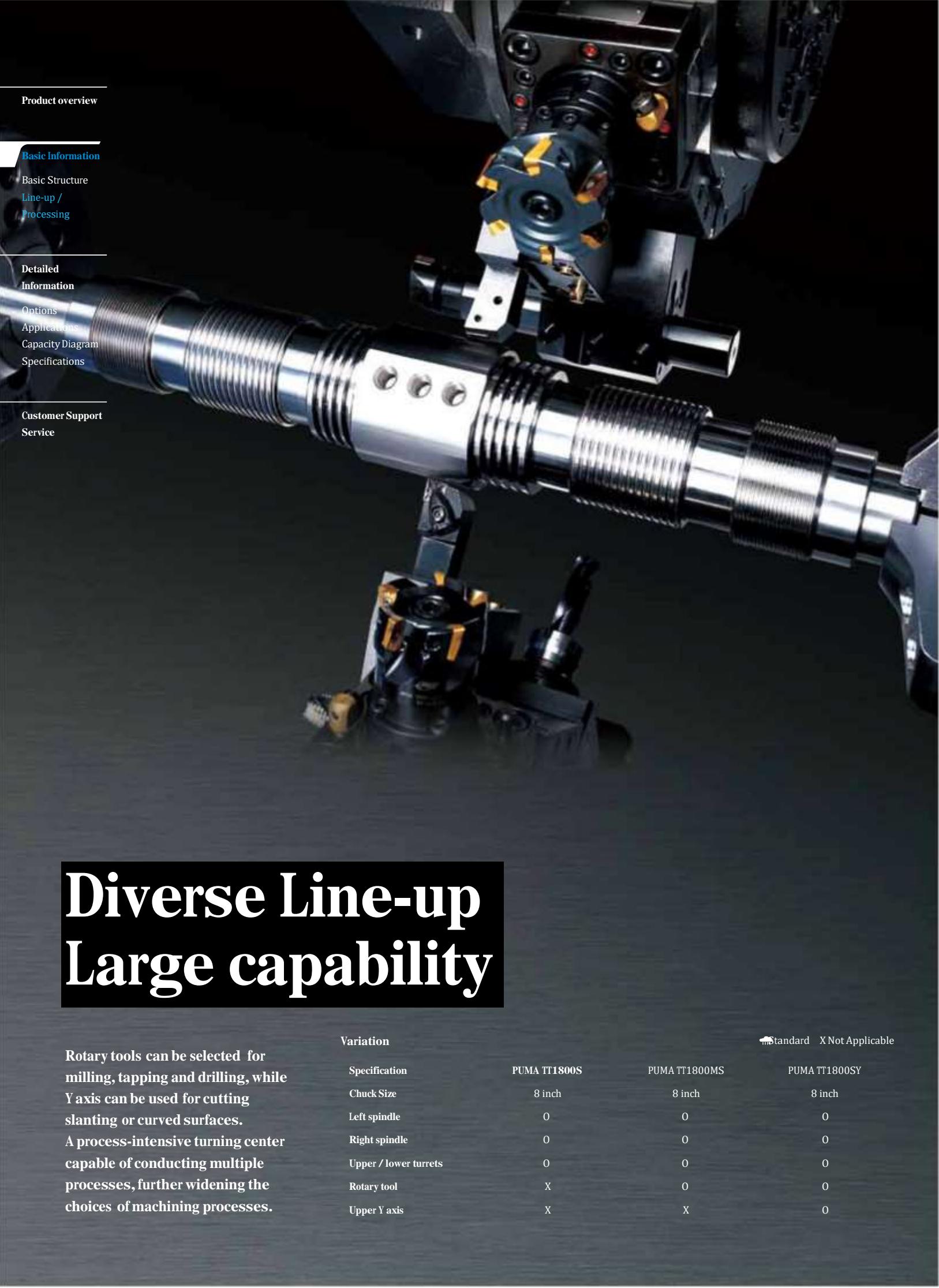
The milling turret including rotary tools features a BMT design standard for higher rigidity. In addition, the minimization of thermal error due to oil and air lubrication of the rotary tools delivers the best milling, drilling and tapping performance in its class.

Basic Information

Basic Structure
Line-up /
Processing

**Detailed
Information**

Options
Applications
Capacity Diagram
Specifications

Customer Support
Service

Diverse Line-up Large capability

Rotary tools can be selected for milling, tapping and drilling, while Y axis can be used for cutting slanting or curved surfaces.
A process-intensive turning center capable of conducting multiple processes, further widening the choices of machining processes.

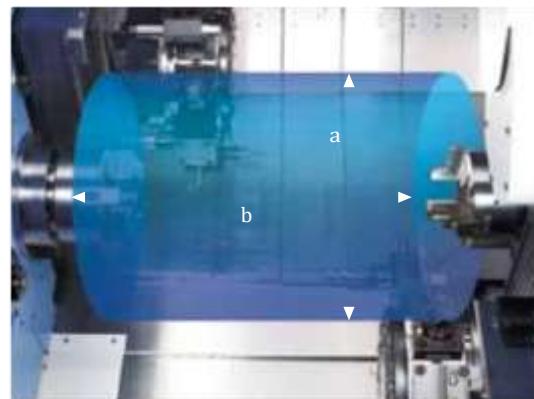
Variation

Specification	PUMA TT1800S	PUMA TT1800MS	PUMA TT1800SY
Chuck Size	8 inch	8 inch	8 inch
Left spindle	0	0	0
Right spindle	0	0	0
Upper / lower turrets	0	0	0
Rotary tool	X	0	0
Upper Y axis	X	X	0

Standard X Not Applicable

Variation, processing

Large capability



(a) max. turning diameter of
230mm (9.1 inch)

(b) max. turning length of
230mm (9.1 inch)

bar working diameter of
65mm (2.6 inch)

Y-axis Milling

Wide variety of multi axis milling cycles can be achieved using the Y axis on the top turret.

Y-axis stroke 100 (± 50) mm (3.9 (± 2.0) inch)		
Y-axis rapid traverse rate 7.5 m/min (295.3 ipm)		

Mill-turning

- Live tool holders are a BMT standard, with many tool holder configurations available.
(angled holders, multi spindle holders, etc)
- Polar milling and Cylindrical milling are standard on machine.

Cutting Concept

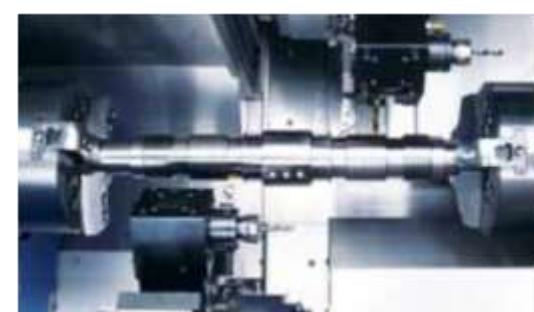
Multi tasking with Right /Left spindle and Upper /Lower turret optimizes productivity.

Long shaft machining concept by synchronising the rotation of both spindles

PUMA TT Series turning centers can double the user's productivity by holding long workpieces securely with synchronized control of the left and right spindles and simultaneous cutting with the upper and lower turrets.



Turning at the same position is carried out with the upper and lower turrets simultaneously.



Different cutting processes can be carried out on a single work piece with the upper and lower turrets simultaneously.

Basic Information

Basic Structure
Line-up /
Processing

Detailed Information

Options
Applications
Capacity Diagram
Specifications

Customer Support

Service

Complex machining with left and right hand spindles, upper and lower turrets

Left spindle

Upper / Lower
turret
simultaneously
machining with
left spindle

**Right spindle**

Upper / Lower
turret
simultaneously
machining with
right spindle



Gear hobbing and polygon turning

**first process and second process simultaneously machining concept**

it can time milled features from spindle to spindle (example : bolt hole pattern on right spindle to a keyway machined from the left spindle)

**First process**

Cutting with the left spindle

**Part transfer**

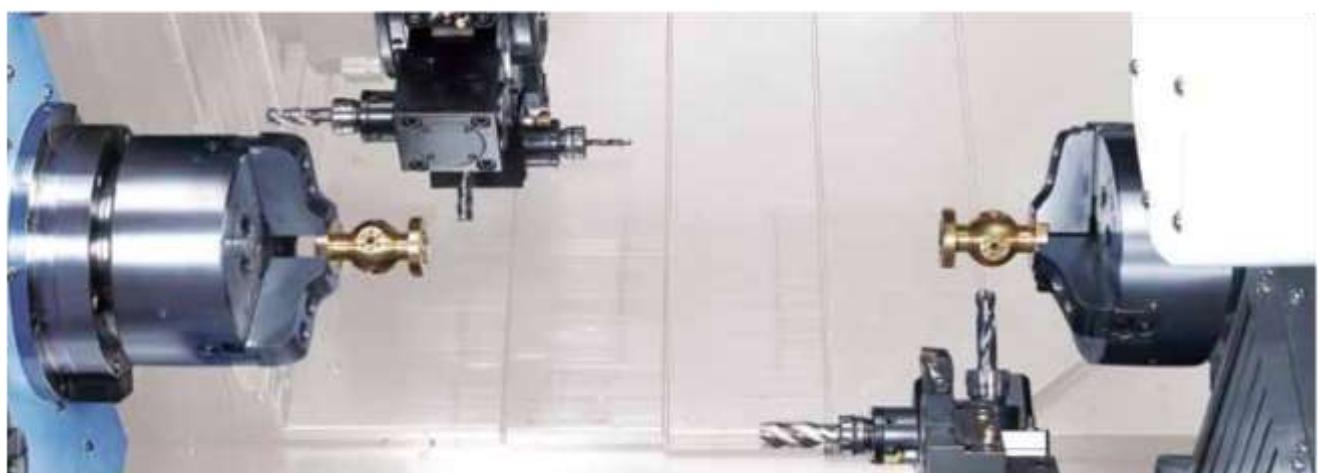
Synchronized rotation and parts feed using
the left and right spindles

**Second process**

Rear side cutting with the right spindle
(First process have been cutting with left spindle)

one machine, two parts concept (same process, same cutting)

PUMA TT Series turning centers double the user's productivity thanks to the independent yet simultaneous operation of the left and right spindles and the upper and lower turrets.



Standard / Optional Specifications

Various options are available to satisfy all the customers' requirements.

Standard Optional X N/A

NO.	Description	Features	PUMA TT1800series
1	Chuck (Left / Right)	210 mm (8 Inch)	
2		None	
3	Jaws (Left / Right)	Soft Jaws	
4		Hardened & Ground Hard Jaws	
5	Chucking option	Dual Pressure Chucking	
6		Chuck Clamp Confirmation	
7	Tailstock	Tail Center For Turret	
8	Coolant Pump (60 / 50Hz)	4.5 / 3.0 Bar	
9		7 / 5, 10 / 7, 14.5 / 10, 28 / 19.5, 70 / 70 bar	
10	Coolant options	Oil Skimmer	
11		Coolant Chiller	
12		Coolant Pressure Switch	
13		Coolant Level Switch	
14		Cooling Flow Switch	
15		High Coolant Interface	
16		Chuck Coolant (Left / Right)	
17		Through Spindle Coolant(T.S.C) For Spindle (Left / Right)	
18		Coolant Gun	
19		Chip Conveyor_Side Type	
20		Chip Conveyor_Rear Type	
21	Chip processing options	Chip Bucket	
22		Air Blow (Left / Right)	
23		Mist Collector	
24		Tool Setter (Manual / Auto)	
25		Parts Catcher And Box	
26	Measurement & Automation	Parts Unloader And Conveyor	
27		Work Ejector	
28		Auto Door	
29		Cut-Off Confirmation	
30		Work / Tool Counter	
31		Robot Interface (PMC I/O, Profibus)	
32		Bar Feeder Interface	
33	Optional devices	Tool Load Monitoring	
34		Linear Scale (X1, X2, Z1, Z2, Y)	
35		Signal Tower	
36		Air Gun	
37		Air Conditioner For Electric Cabinet	
38		Light For Electric Cabinet	
39		Extra M-Code (4ea)	
40		Auto Power Off	

*For further details of the range of options, please contact Doosan.

Peripheral equipments

Basic Information

Basic Structure
Line-up /
Processing

Detailed Information

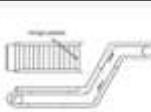
Options
Applications
Capacity Diagram
Specifications

Customer Support

Service

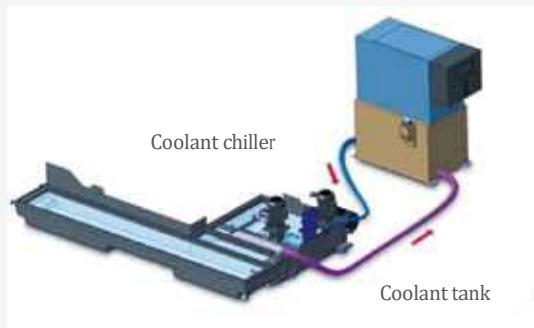
Chip Conveyor (right side) option

The chip conveyor boasts excellent chip disposal performance, a stable design, and superior operation and maintenance convenience. Users can select the optimal type for specific requirements to improve the efficiency of their work space.

Name	Hinged belt	Magnetic scrapper	Drum filter (single type)	Drum filter (double type)
Application	Steel	Cast steel, iron	Cast	Steel, cast, nonferrous metals
Features	- General use - Suitable for steel works producing 30 mm chips or longer	- Easy-to-understand manual - Chips are scraped up and discharged	- Suitable for sludge - Suitable for nonferrous metals	- Suitable for long and short chips - Cooling water filtering function
Shape				

Coolant Chiller (recommended) option

A detachable-type coolant chiller is recommended to control temperature and minimize thermal error.



70 Bar High Pressure Coolant option

70 bar high pressure coolant suitable for high productivity.



Optional devices option

Auto tool setter



Coolant Blower



Singnal tower



Collet Chuck



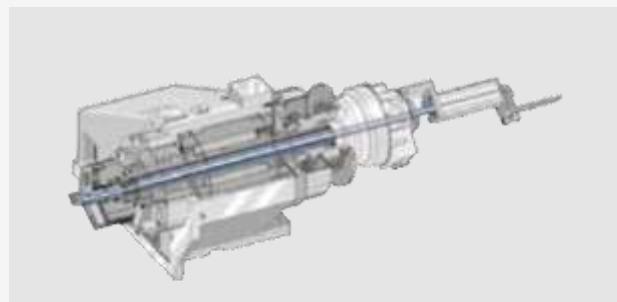
Oil skimmer



Mist Collector

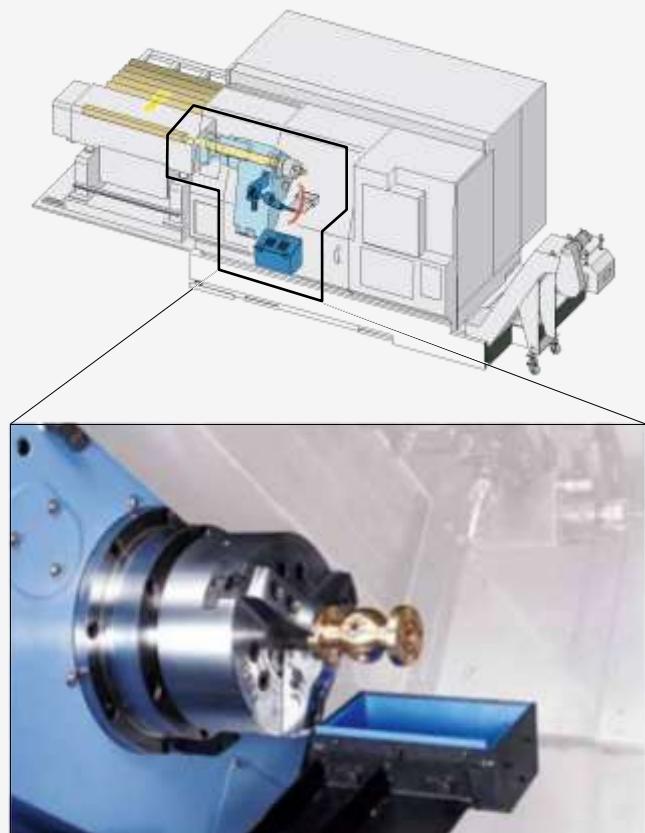


Work Ejector



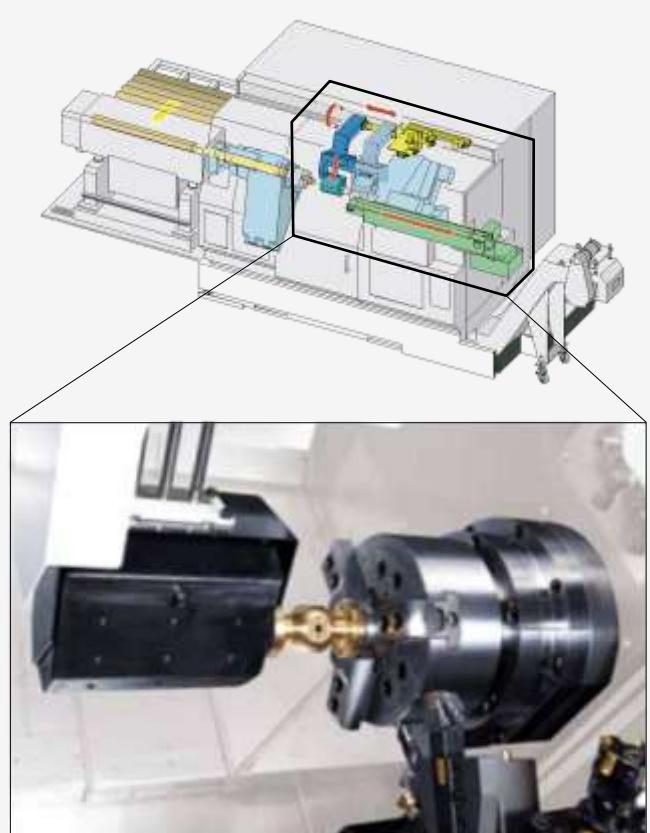
Left Spindle Parts Catcher option

Single operation part produced on the left spindle, or bar remnant can be ejected into the bucket.



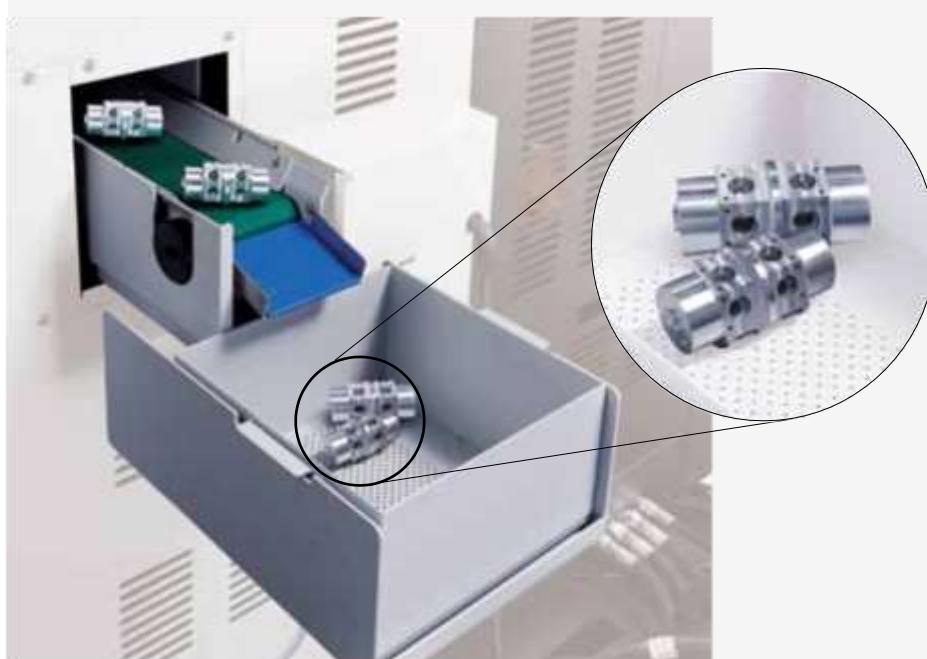
Right Spindle Parts Unloader and Work Ejector option

Work processed by the right spindle is delivered to the parts unloader by the work ejector and then discharged to the parts conveyor.



option

Finished workpieces are transferred to the indexable output belt conveyor which discharges them to a receiving container.



Maximum material size for unloader / conveyor system

Max. work diameter

Ø65 mm (2.6 inch)

Max. work length

150 mm (5.9 inch)

Max. work weight

3kg (6.6 lb)



FANUC 31i

Basic Information

Basic Structure
Line-up /
Processing

Detailed Information

Options
Applications
Capacity Diagram
Specifications

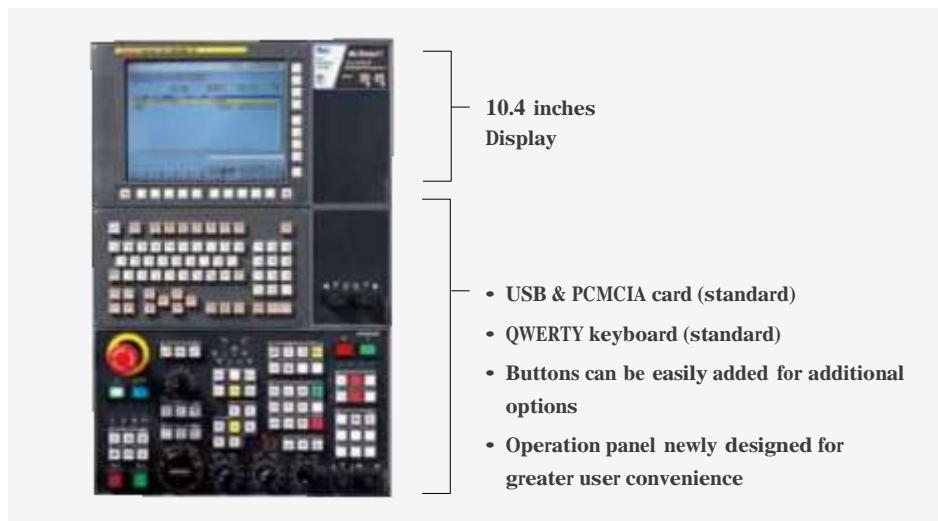
Customer Support

Service

FANUC CNC optimized for DOOSAN's machine tools maximizes users' productivity.

User-friendly OP Panel

The operation panel of new design enhances operating convenience by common buttons and layout, and uses qwerty type keyboard for easy and fast operation.



10.4 inches
Display

- USB & PCMCIA card (standard)
- QWERTY keyboard (standard)
- Buttons can be easily added for additional options
- Operation panel newly designed for greater user convenience

Productivity Improvement

non-cutting time has been reduced by speeding up individual machine element operating speeds and increasing acceleration / deceleration characteristics.

Non-cutting time

Reduced by
10%

Cycle Time

Multi M code

Up to 3 M-code commands can be used for a block, thereby enabling simultaneous processing and further reducing non-cutting time.

M14 M31 M69;

M14	M31	M69	
ACTION	ACTION	ACTION	Cycle time reduce
M code FIN			

Real time custom macro function

During operation of the parts unloader of the right spindle, this function allows the lower turret to conduct the cutting operation for the left spindle. This function also further improves the productivity.

Upper turret

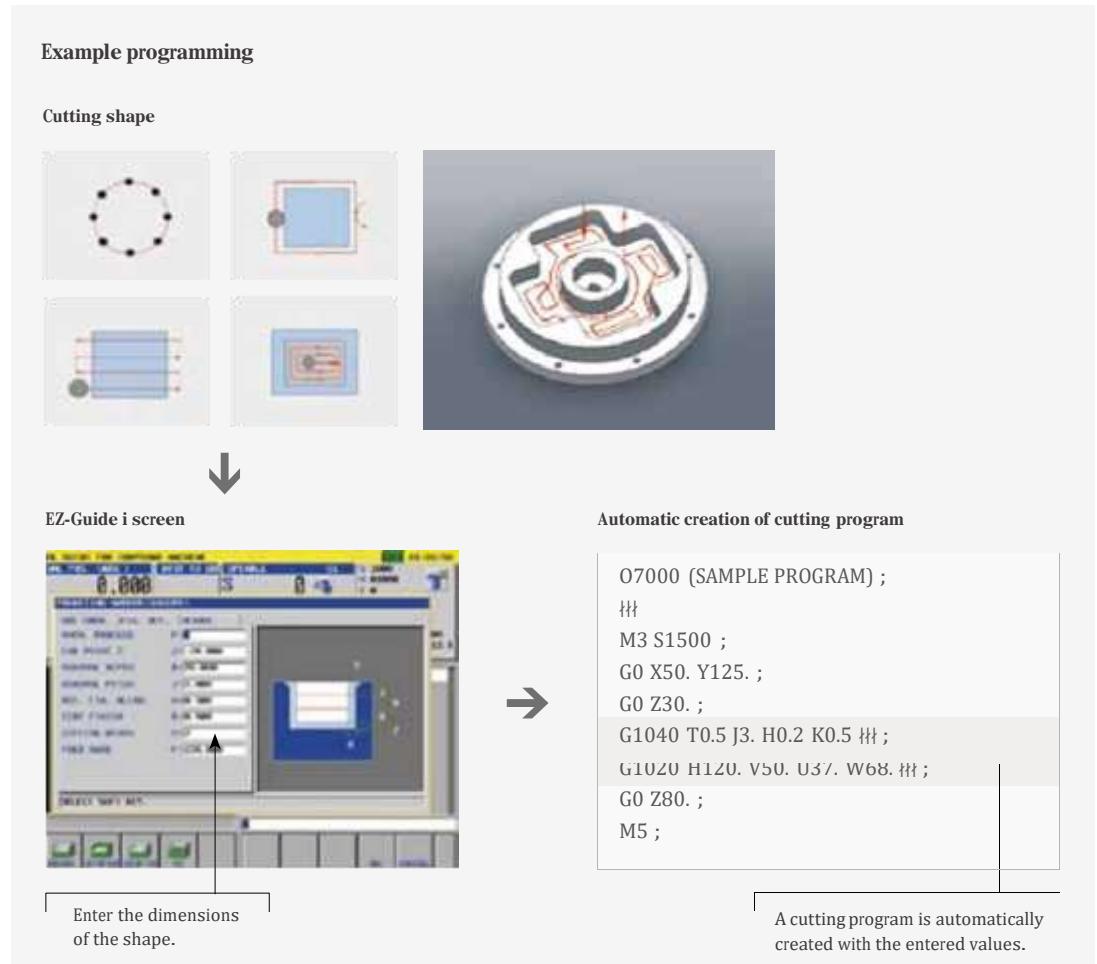
Left spindle

Right
spindle

Lower turret

EZ-Guide i

Using the DOOSAN EZ-Guide i, users can create a cutting program for any desired shape, including patterns, by entering figures only.



Easy Operation Package

Doosan's Easy Operation Package (EOP) supports the user with functions relating to tool data, error diagnostics, set up and machine monitoring.

Tool Load Monitoring Function

During cutting operation, abnormal load caused by wear or damage of the tool is detected and an alarm is triggered to prevent further damage.



Tool monitoring screen

Convenience of Maintenance and Service

The condition and service procedures of the sensors are provided for easy maintenance and servicing of major units.



Turret maintenance and service screen

Basic Information

Basic Structure
Line-up /
Processing

Detailed Information

Options
Applications
Capacity Diagram
Specifications

Customer Support

Service

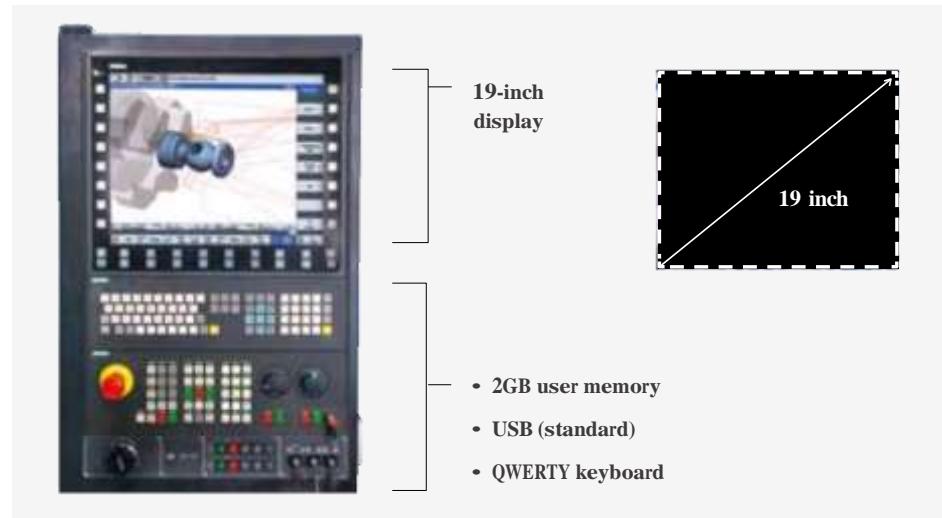


SIEMENS 840D

SIEMENS CNCs have been adopted and optimized for DOOSAN's machine tools to maximize users' productivity.

Large 19-inch Screen

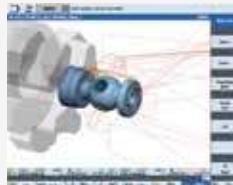
Two path programs are displayed simultaneously in the large 19-inch screen for enhanced user convenience.



Conversational Convenient function

The machining monitoring function developed on the basis of the Shop Turn – an interactive machining support function of SIEMENS – provides users with cutting, servicing and maintenance screens for easy and convenient machine operation.

Cutting and operation support function



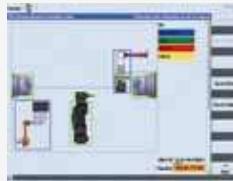
This function shows a cutting and tool path simulation of a cutting program on a real-time basis.



The automation units (parts catcher, parts unloader) can be easily controlled via interactive windows.

Shop-turn mode[various] → [attachments]

Operation safety function



Protection Zone Synchronized Actions checks the interference between the turret and the spindle to prevent collisions that can be caused by the operator.

[Custom] → [Protection zones]

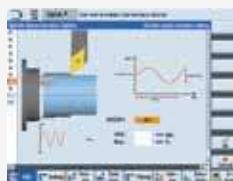
Maintenance and service convenience function



Maintenance and service of major units and peripheral devices, timer setting and parts counter setting can be easily carried out on a convenient screen.

[offset] → [operating parameter] → [TC service]

Machining accuracy improvement



The NC controls spindle speed at an optimal level for precision threading and turning, making it possible to improve surface roughness automatically.

[various] → [attachment] → [DSSV]

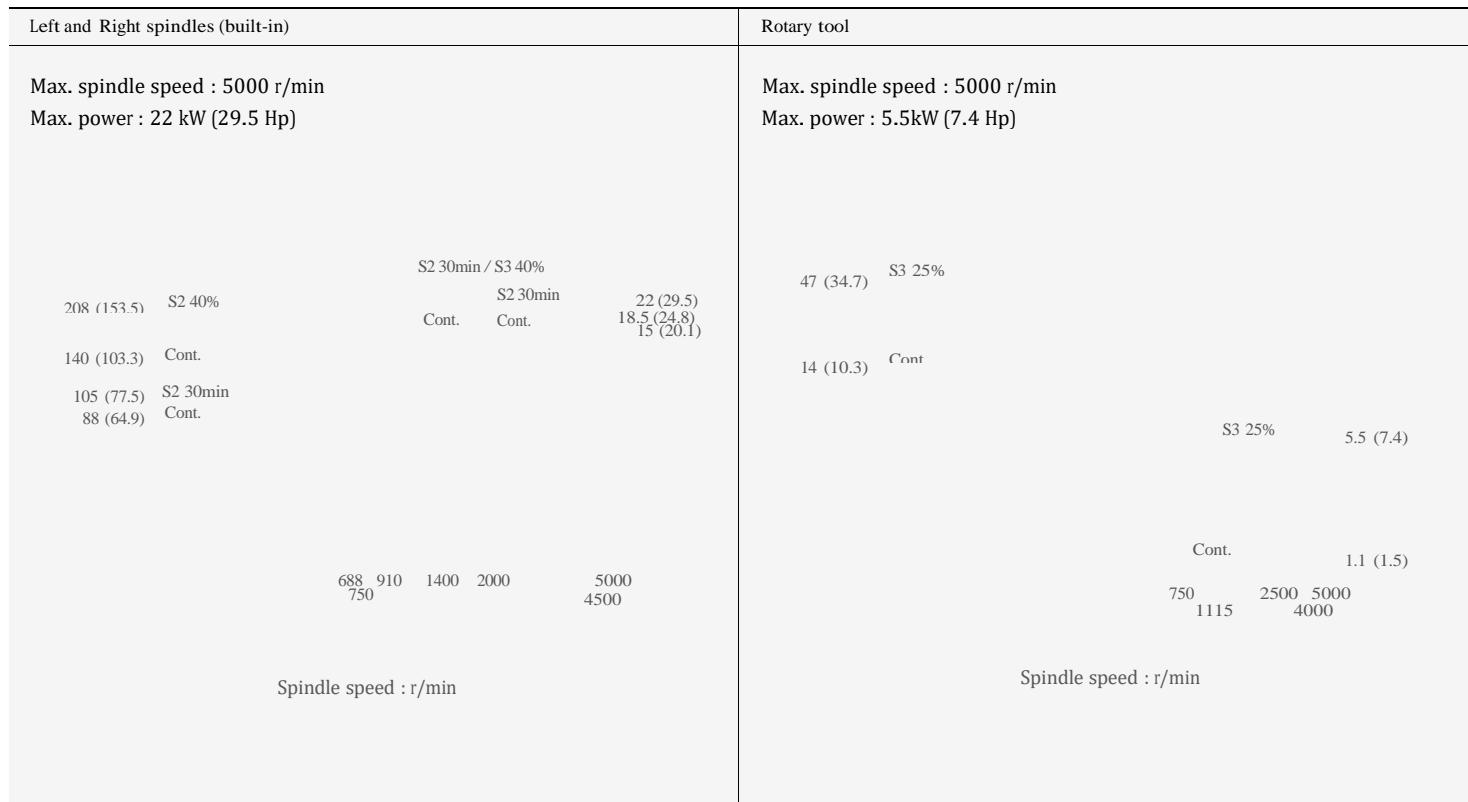


Before applying the function

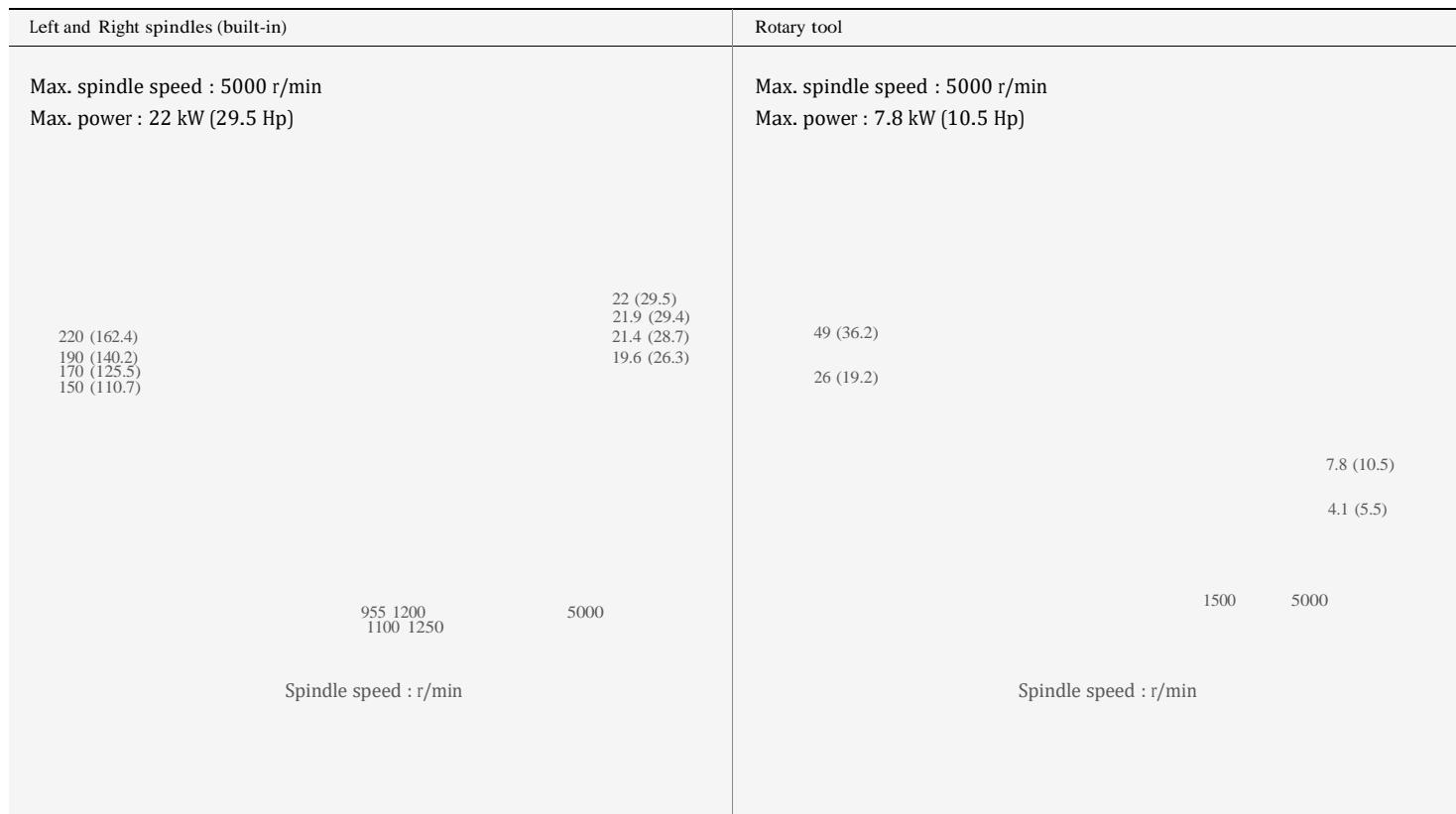
After applying the function

Spindle Power-Torque Diagram

FANUC



SIEMENS



Tooling System

Basic Information

Basic Structure
Line-up /
Processing

Detailed Information

Options
Applications
Capacity Diagram
Specifications

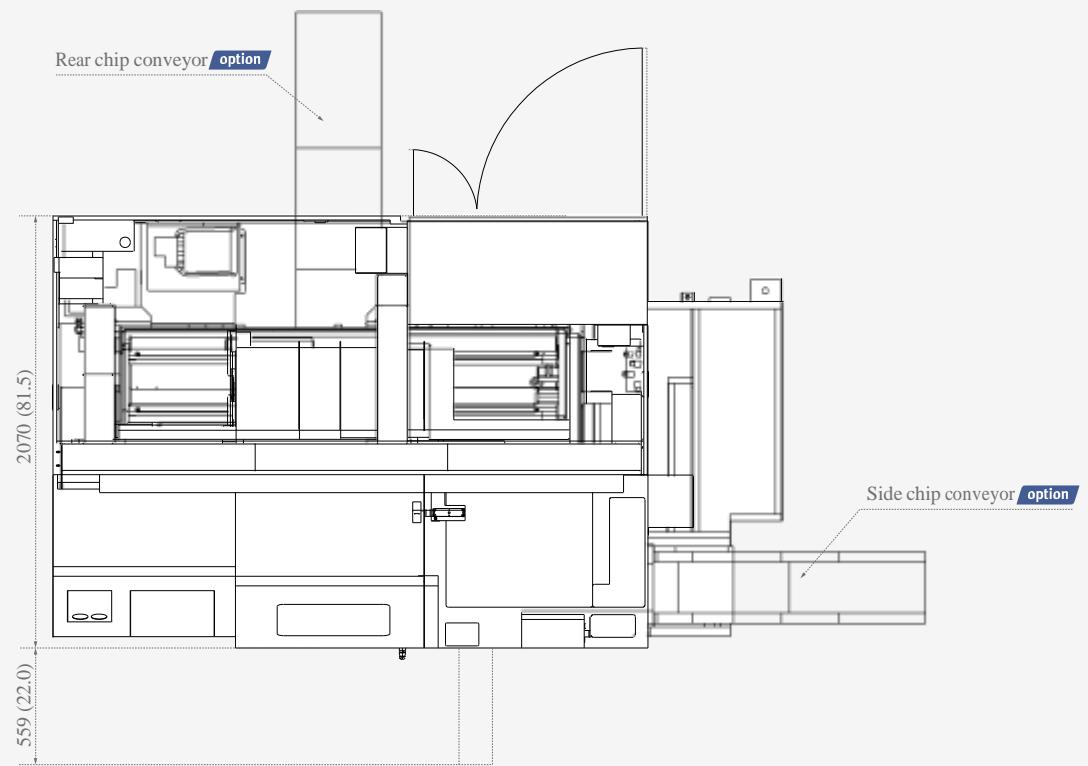
Customer Support

Service

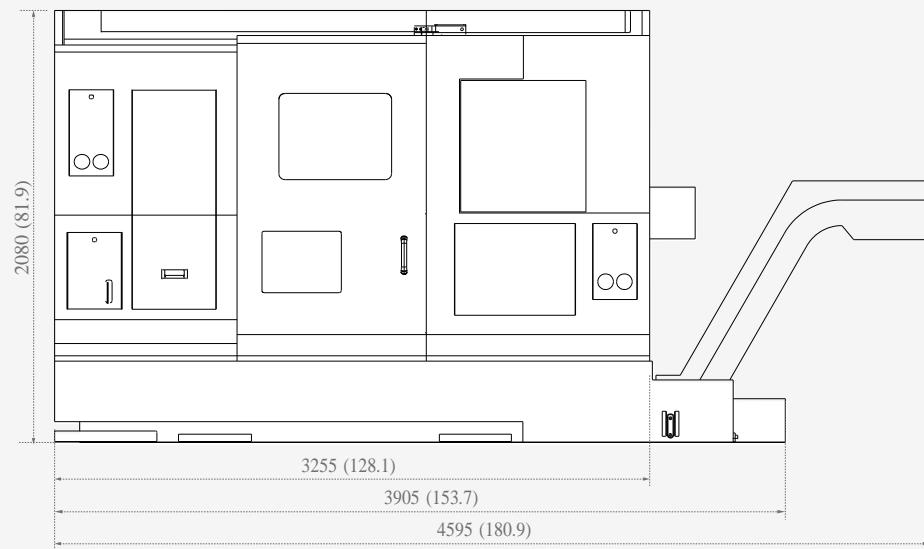
PUMA TT1800S / MS / SY

Unit : mm (inch)

Top View



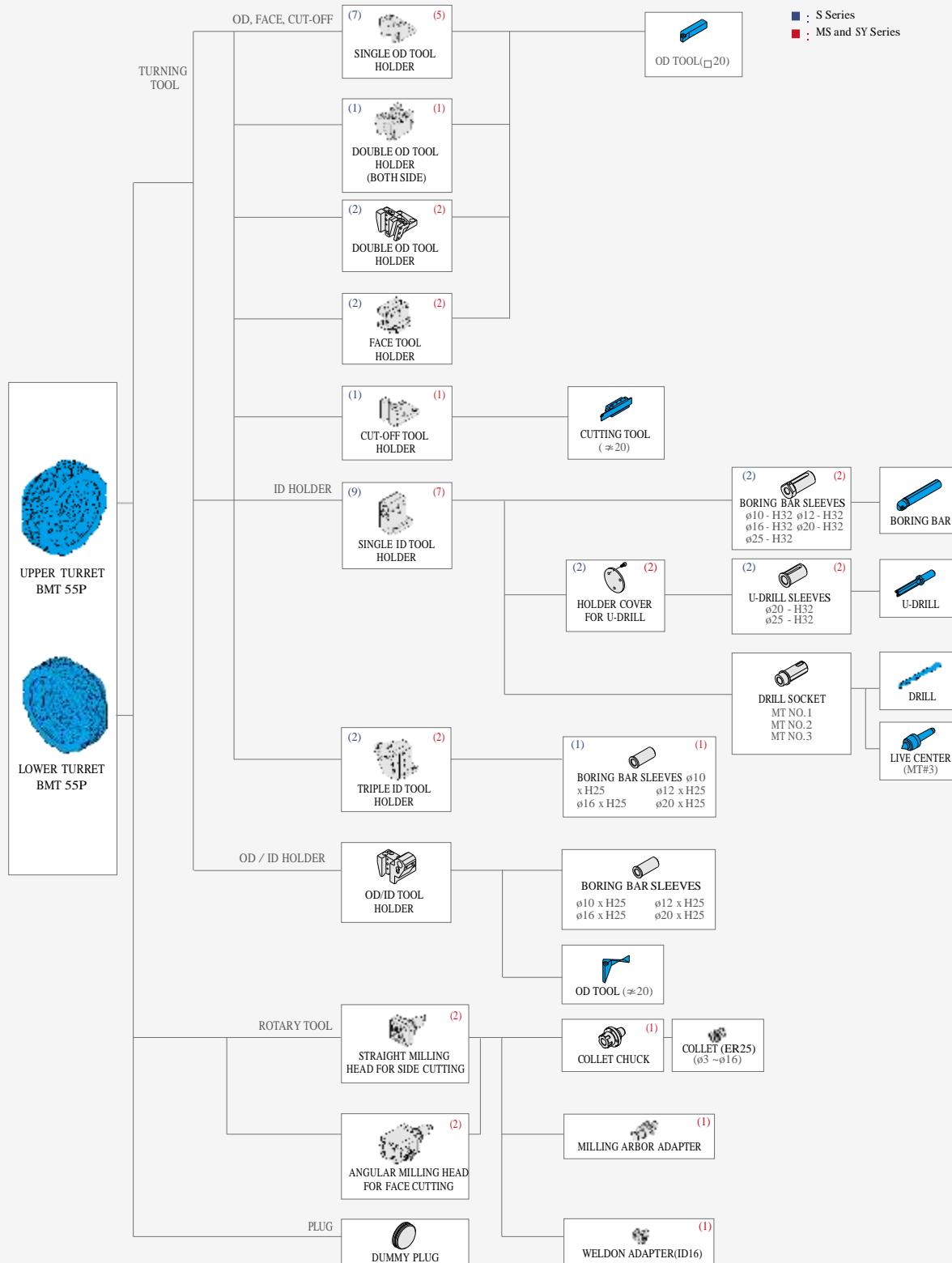
Front View



External Dimensions

PUMA TT1800S / MS / SY

Unit : mm (inch)



Working Range Diagram

Basic Information

Basic Structure Line-up / Processing

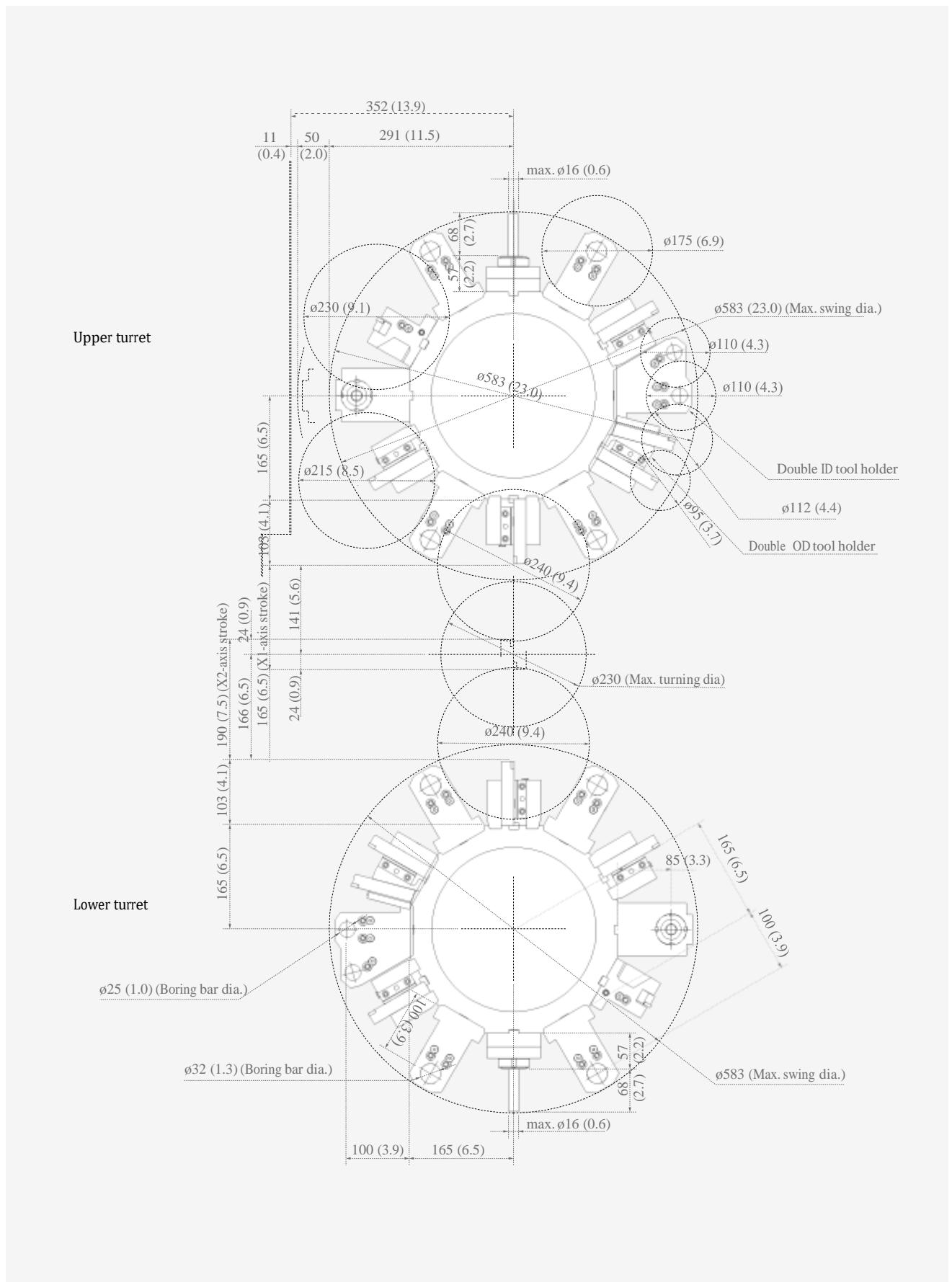
Detailed Information

Options
Applications
Capacity Diagram
Specifications

Customer Support Service

PUMA TT1800S / MS / SY

Unit : mm (inch)

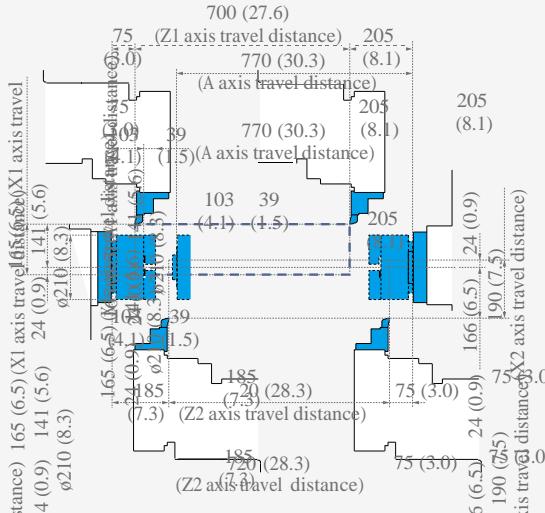


Tool Interference Diagram

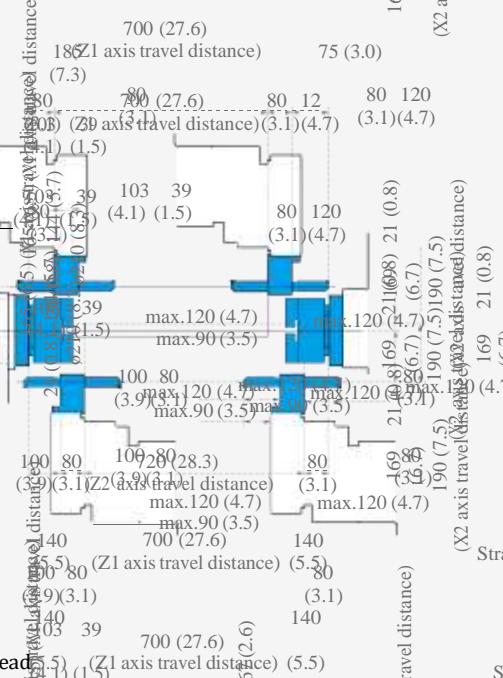
PUMA TT1800S / MS / SY

Unit : mm (inch)

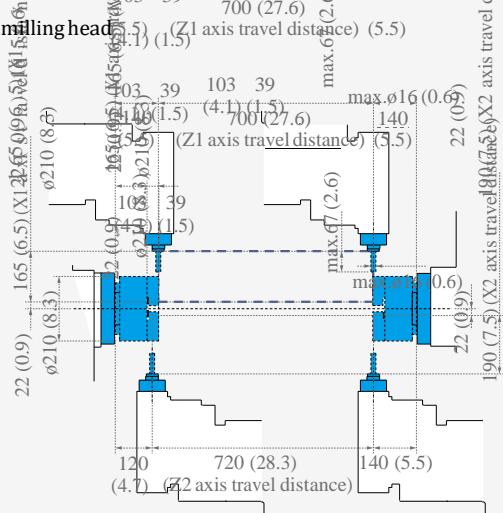
Single OD Tool holder



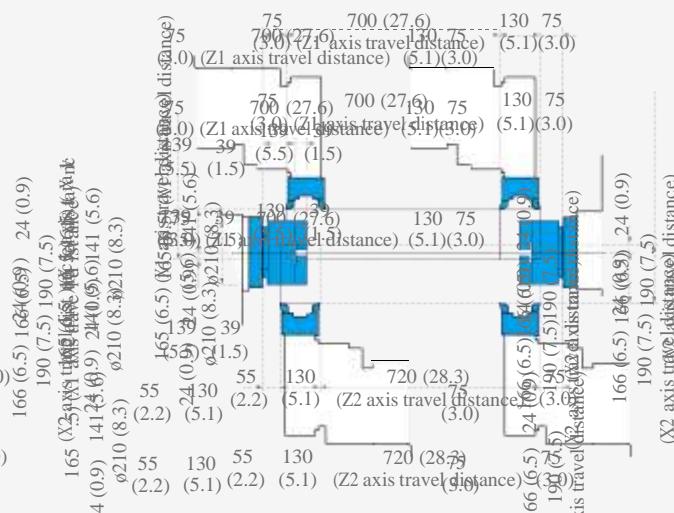
ID Tool holder



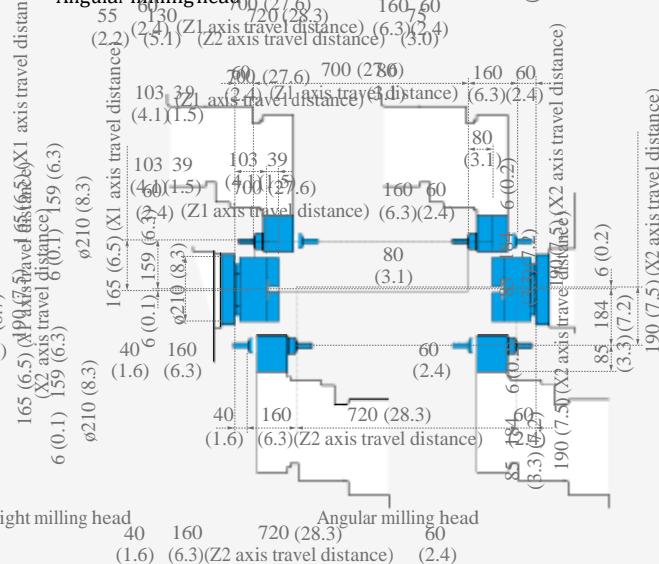
Straight milling head



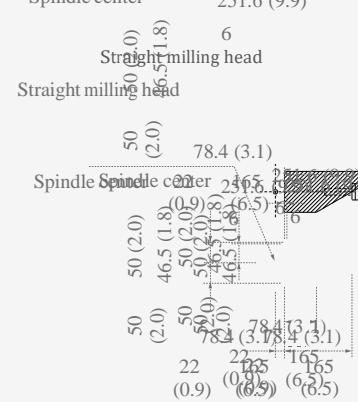
Double OD Tool holder



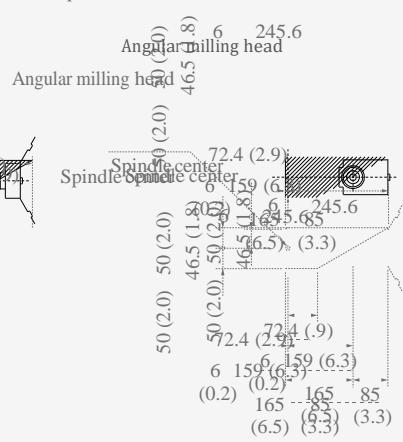
Angular milling head



Y axis travel distance



Spindle center



NC Unit Specifications



Basic Information

Basic Structure
Line-up /
Processing

Detailed Information

Options
Applications
Capacity Diagram
Specifications

Customer Support Service

Standard Optional X Not applicable

	Description	Unit	PUMA TT1800S	PUMA TT1800MS	PUMA TT1800SY
Capacity	Swing over bed	mm (inch)	230 (9.1)		
	Swing over saddle	mm (inch)	230 (9.1)		
	Recommended turning diameter	mm (inch)	210 (8.3)		
	Max. turning diameter	mm (inch)	Upper turret: 230 (9.1) / Lower turret: 230 (9.1)		
	Max. turning length	mm (inch)	230 (9.1)		
	Chuck size	inch	8		
	Bar working diameter	mm (inch)	65 (2.6)		
Feedrate	X1 / 2 axes	mm (inch)	X1: 165 (6.5) / X2: 190 (7.5)		
	Z1 / 2 axes	mm (inch)	Z1: 700 (27.6) / Z2: 720 (28.3)		
	Y-axis	mm (inch)	-	-	100 (3.9)
	A-axis	mm (inch)	770 (30.3)		
Rapid traverse	X1 / 2 axes	m/min (ipm)	20 (787.4)		
	Z1 / 2 axes	m/min (ipm)	40 (1574.8)		
	Y-axis	m/min (ipm)	-	-	7.5 (295.3)
	A-axis	m/min (ipm)	40 (1574.8)		
Left spindle / Right spindle	Spindle speed	r/min	5000		
	Spindle motor power (FANUC) (30 min / cont.)	kW (Hp)	22 / 15 (29.5 / 20.1)		
	Spindle motor power (SIEMENS) (S6 40% / cont.)	kW(Hp)	22/19.6 (29.5/26.3)		
	Max. spindle torque (FANUC)	N·m (ft-lbs)	208 (153.5)		
	Max. spindle torque (SIEMENS)	N.m (ft-ibs)	220 (162.4)		
	Spindle nose	ASA	A2#6		
	Spindle bearing diameter	mm (inch)	110 (4.3)		
	Spindle inner diameter	mm (inch)	76 (3.0)		
	C-axis min. indexing angle	deg	360 (in 0.001deg.increment)		
Turret	No. of tool stations (Upper + Lower)	ea	24 + 24		
	OD tool size	mm (inch)	20 x 20 (0.8 x 0.8)		
	Max. ID tool size	mm (inch)	32 (1.3)		
	Turret Indexing time	sec	0.15		
	Max. rotary tool speed	r/min	-	5000	
	Rotary tool motor power (FANUC) (S3 25%/cont.)	kW (Hp)	5.5 / 1.1 (7.4 / 1.5)		
	Rotary tool motor power (SIEMENS) (S6 25% / cont.)	kW (HP)	7.8/4.1 (10.5/5.5)		
Power Source	Power consumption	kVA	75.21		
Machine dimensions	Length	mm (inch)	3905 (153.7)		
	Width	mm (inch)	2070 (81.5)		
	Height	mm (inch)	2080 (81.9)		
	Weight	kg (lb)	8350 (18408.3)	8600 (18959.5)	8800 (19400.4)
Control	NC system		FANUC 31i / SIEMENS 840D		

Machine Specifications

**FANUC
31i**

NO.	Division	Item	Spec.	Fanuc 31i		
				S	MS	SY
1	Control axes	Control paths		2 Path	2 Path	2 Path
2		Controlled axes		5 (X1, Z1, X2, Z2, A)	7 (X1, Z1, C1, X2, Z2, C2, A)	8 (X1, Z1, C1, Y, X2, Z2, C2, A)
3		Simultaneously controlled axes		4 axes	4 axes	4 axes
4		Axis control by PMC		---	---	---
5		Cs contouring control		X	---	---
6		Synchronous/Composite control		---	---	---
7		Torque control		---	---	---
8		Increment system	ISA, IS-B	---	---	---
9		HRV2 control		---	---	---
10		Inch / metric conversion		---	---	---
11		Stored limit check before move		---	---	---
12		Chamfering on / off		---	---	---
13		Interference check for rotary area		---	---	---
14		Unexpected disturbance torque detection function		---	---	---
15		Position switch		---	---	---
16	Operation	Tool retract and recover		---	---	---
17		Dry run		---	---	---
18		Single block		---	---	---
19		Handle interruption		---	---	---
20		Incremental feed	x1, x10, x100	---	---	---
21		Manual handle retrace		---	---	---
22		Active block cancel		---	---	---
23	Interpolation	Nano interpolation		---	---	---
24		Linear interpolation		---	---	---
25		Circular interpolation		---	---	---
26		Polar coordinate interpolation		---	---	---
27		Cylindrical interpolation		---	---	---
28		Helical interpolation		X	---	---
29		Thread cutting, synchronous cutting		---	---	---
30		Multi threading		---	---	---
31		Thread cutting retract		---	---	---
32		Continuous threading		---	---	---
33		Variable lead thread cutting		---	---	---
34		Circular thread cutting		---	---	---
35		Polygon machining with two spindles		---	---	---
36		High-speed skip	Input signal is 8 points.	---	---	---
37		3rd/4th reference position return		---	---	---
38		Balanced cutting	Only for more than 2 path control	---	---	---
39	Feeding	Bell-shaped acceleration/deceleration after cutting feed interpolation		---	---	---
40		Override cancel		---	---	---
41		AI contour control I		---	---	---
42		AI contour control II		---	---	---
43		Rapid traverse block overlap		---	---	---
44	Programming	Optional block skip	9 pieces	---	---	---
45		Absolute / incremental programming	Combined use in the same block	---	---	---
46		Diameter / Radius programming		---	---	---
47		Automatic coordinate system setting		---	---	---
48		Workpiece coordinate system	G52 - G59	---	---	---
49		Workpiece coordinate system preset		---	---	---
50		Addition of workpiece coordinate system	48 pairs	---	---	---
51		Addition of workpiece coordinate system	300 pairs	---	---	---
52		Direct drawing dimension programming		---	---	---
53		Chamfering / Corner R		---	---	---
54		Custom macro		---	---	---
55		Addition of custom macro common variables	#100 - #199, #500 - #999	---	---	---

NC Unit Specifications

Standard
 Optional
 X Not applicable

**FANUC
31i**

Basic Information

Basic Structure
Line-up /
ProcessingDetailed
InformationOptions
Applications
Capacity Diagram
SpecificationsCustomer Support
Service

NO.	Division	Item	Spec.	Fanuc 31i		
				S	MS	SY
56	Programming	Custom macro common variables between each path	Only for more than 2 path control. Included in Custom macro.			
57		Interruption type custom macro				
58		Canned cycle				
59		Multiple repetitive cycles	G70~G76			
60		Multiple repetitive cycles II	Pocket profile			
61		Canned cycle for drilling				
62		Automatic corner override				
63		Custom software (Total amount of each path)	12MByte			
64		Coordinate system shift				
65		Direct input of coordinate system shift				
66		Real time custom macro				
67		Pattern data input				
68	Interactive programming	EZ Guidei (Conversational Programming Solution)				
69		Easy Operation Package				
70	Auxiliary / spindle function	High-speed M / S / T / B interface				
71		Waiting M codes of high-speed type	Only for more than 2 path control			
72		Constant surface speed control				
73		Spindle override	0 - 150%			
74		Spindle orientation				
75		Spindle synchronous control				
76		Rigid tap				
77		Arbitrary speed threading				
78	Tool function / tool compensation	Tool offset pairs	99-pairs			
79			128 / 200 / 400 / 499 / 999 pair			
80		Common offset memory between each path	Only for more than 2 path control			
81		Tool offset				
82		Tool radius/Tool nose radius compensation				
83		Tool geometry/wear compensation				
84		Automatic tool offset				
85		Direct input of offset value measured B				
86		Tool life management				
87	Tool function / tool compensation	Backlash compensation for each rapid traverse and cutting feed				
88		Stored pitch error compensation				
89	Editing	Part program storage size & Number of registerable programs	640M (256KB)_500 programs			
90			1280M (512KB)_1000 programs			
91			1MB / 2MB / 4MB / 8MB 1000 / 2000 / 4000 programs			
92			Program protect			
93		Password function				
94		Playback				
95		Memory card program edit & operation	Max 63 programs			
96	Data input / output	Fast data server				
97		External data input				
98		Memory card input / output				
99		USB memory input / output				
100		Automatic data backup				
101	Interfacing	Embedded Ethernet				
102		Fast Ethernet				
103	Other functions	Display unit	10.4" color LCD			
104	Robot interface	Robot interface with PMC I/O module				
105		Robot interface with PROFIBUS-DP				

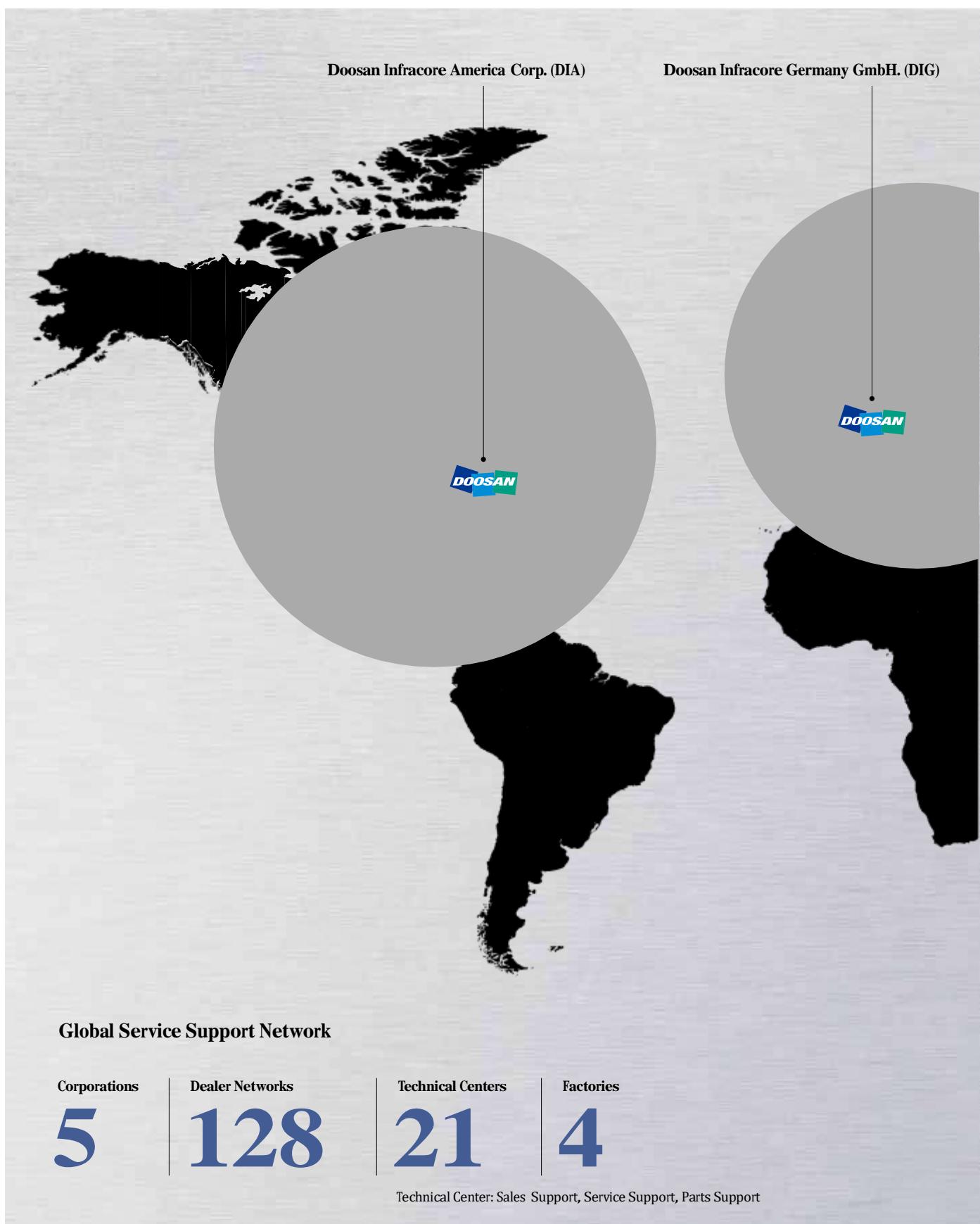
NC Unit Specifications

Standard  Optional  X Not applicable

**SIEMENS
840D**

NO.	Division	Item	Spec.	S 840D
				PUMA TT series
1	Control axes	Simultaneously controlled axes	Positioning (G00) / Linear interpolation (G01) : 3 axes Circular interpolation (G02, G03) : 2 axes	
2		Backlash compensation		
3		Leadscrew error compensation		
4		Measuring system error compensation		
5		Feedforward control	velocity-dependent	
6		Follow up mode		
7		Programmable acceleration		
8		Least command increment	0.001mm (0.0001 inch)	
9		Least input increment	0.001mm (0.0001 inch)	
10	INTERPOLATION & FEED FUNCTION	2nd reference point return	G75 FP=2	
11		3rd / 4th reference return	G75 FP=3, 4	
12		Linear interpolation	Max. 4	
13		Circular interpolation	G02, G03	
14		Helical interpolation		
15		Universal interpolator NURBS		
16		Polynomial interpolation		
17		Spline interpolation (A, B and C splines)		
18		Involute interpolation		
19		Separate path feed for corners and chamfers		
20	SPINDLE FUNCTION	Retraction for rigid tapping		
21		Rigid tapping		
22	TOOL FUNCTION	3D Tool radius compensation		
23		Number of tools / cutting edges in tool list		600 / 1500
24		Tool length compensation		
25		Replacement tools for tool management		
26		Monitoring of tool life and workpiece count		
27		Manual measurement of tool offset		
28		Loading and unloading of tools		
29		Number of subroutine passes <= 9999		
30	PROGRAMMING & EDITING FUNCTION	Polar coordinates		
31		Dimensions metric/inch, changeover manually or via program		
32		Dynamic preprocessing memory FIFO		
33		Look ahead number of blocks		150
34		Geometry axes, switchable online in the CNC program		
35		Parts programs on NCU, max. number		1000
36		Workpieces on NCU, max. number		250
37		ShopTurn / ShopMill Machining step programming		
38		Technology cycles for drilling/milling		
39		Pocket milling free contour and islands stock removal cycle		
40		2D simulation		
41		3D simulation, finished part		
42		Simultaneous recording		
43	OTHERS FUNCTIONS (Operation, setting & Display, etc)	Execution from USB or CF card interface on operator panel front		
44		Execution from HMI memory on NCU CF card		
45		19.0" color display		
46		Multi-channel display		
47		2D representation of 3D protection areas / work areas		
48		Software and hardware limit switches		
49		Position monitoring		
50		2D / 3D protection zones		
51		Contour monitoring		
52		Alarms and messages		
53		RCS Commander (viewer function)		
54		Automatic measuring cycles		
55		Contour handwheel		
56		Integrate screens in SINUMERIK Operate with SINUMERIK Integrate Run MyScreens		
57		MDynamics 3-axis		

Responding to Customers Anytime, Anywhere



Doosan Machine Tools' Global Network, Responding to Customer's Needs nearby, Anytime, Anywhere

Doosan machine tools provides a system-based professional support service before and after the machine tool sale by responding quickly and efficiently to customers' demands. By supplying spare parts, product training, field service and technical support, we can provide top class support to our customers around the world.

Doosan Infracore Yantai Factory (DIY)

Doosan Infracore Construction Equipment
India Pvt. Ltd. (Machine Tool Div.) (DICE)

DIY Shanghai Office

Doosan Infracore Seoul Office

Doosan Infracore Namsan Factory

Doosan Infracore Daewon Factory
Doosan Infracore Sungju Factory

Domestic Service Support Network

Integrated
Support
Centers

2

Sales Branch
Offices

7

Post-Sales
Service
Centers

6

Designated
Repair
Service
Centers

31

Customer Support Service

We help customers to achieve success by providing a variety of professional services from pre-sales consultancy to post-sales support.

Supplying Parts



- Supplying a wide range of original Doosan spare parts
- Parts repair service

Field Services



- On site service
- Machine installation and testing
- Scheduled preventive maintenance
- Machine repair

Technical Support



- Supports machining methods and technology
- Responds to technical queries
- Provides technical consultancy

Training



- Programming / machine setup and operation
- Electrical and mechanical maintenance
- Applications engineering

Major Specifications

PUMA TT1800 series



Specification	UNIT	PUMA TT1800S / MS / SY
Max. turning diameter	mm (inch)	230 (9.1)
Max. turning length	mm (inch)	230 (9.1)
Chuck size	inch	8
Bar working diameter	mm (inch)	65 (2.6)
Spindle speed (Left spindle / Right spindle)	r/min	5000
Spindle motor power (Left spindle / Right spindle)	kW (Hp)	22 / 15 (30 min / cont.) (29.5 / 20.1) (FANUC) 22/19.6 (S6 40% / cont.) (29.5 / 26.3) (SIEMENS)
NC system	-	FANUC 31i / SIEMENS 840D



Doosan Machine Tools

<http://www.doosanmachinetools.com>

Optimal Solutions for the Future

Head Office

Doosan Tower 20th FL., 275, Jangchungdan-Ro
(St), Jung-Gu, Seoul
Tel +82-2-3398-8693 / 8671 / 8680
Fax +82-2-3398-8699

Doosan Infracore America Corp.

19A Chapin Rd., Pine Brook, NJ 07058, U.S.A.
Tel +1-973-618-2500
Fax +1-973-618-2501

Doosan Infracore Germany GmbH

Emdener Strasse 24, D-41540 Dormagen,
Germany
Tel +49-2133-5067-100
Fax +49-2133-5067-001

Doosan Infracore Yantai Co., LTD

13 Building, 140 Tianlin Road, Xuhui District,
Shanghai, China (200233)
Tel +86-21-6440-3384 (808, 805)
Fax +86-21-6440-3389

Doosan Infracore Construction Equipment

India Pvt. Ltd. (Machine Tool Div.)
106 / 10-11-12, Amruthahalli, Byatarayanapura,
Bellary road, Bangalore-560 092, India
Tel +91-80-4266-0122 / 121 / 100



Doosan International South East Asia

Pte Ltd.
42 Benoi Road, Jurong 629903, Singapore
Tel +65-6499-0200
Fax +65-6861-3459

■For more details, please contact Doosan.

■The specifications and information above-mentioned may be changed without prior notice.